

SLG ASAR

Work Order ID 69485

Wednesday, May 11, 2011 12:55:31 PM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11/18/11

5/11/11

5/11/11

5/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69485

Wednesday, May 11, 2011 12:55:31 PM



Page 2

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PP
69485

0.00

Packaging

P. 11/11/11

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/08

11-08-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 69485

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)






Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	8.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST506</div> <div>8</div> <div></div> </div>													
<div> <div>66563</div> <div>2</div> <div></div> </div>													
<div> <div>68363</div> <div>6</div> <div></div> </div>													
D2535  Spring		Manufactured	No			100	Each	41.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST504</div> <div>41</div> <div></div> </div>													
<div> <div>66764</div> <div>41</div> <div></div> </div>													
D2537  Bushing		Manufactured	No			100	Each	32.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST504</div> <div>32</div> <div></div> </div>													
<div> <div>66972</div> <div>32</div> <div></div> </div>													
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
<div> <div>BG9490</div> <div>(12)</div> <div></div> </div>													
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			
<div> <div>BG9492</div> <div>(12)</div> <div></div> </div>													

D40 86-210

1/2

70800

69495

69899

5/11/08/02

5/11/08/02

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Picklist Print

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Page 2

Work Order ID: 69485

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D3917-3 Manufactured No

100 Each

0.0000

6

6



Washer

D3953-3 Manufactured No

100 Each

3.0000

2

2



Gas Spring Stud, Lid

Location

Loc Qty

Loc Code

ST096

3

68230

3

D3953-7 Manufactured No

100 Each

20.0000

2

2



Spring Spacer

Location

Loc Qty

Loc Code

ST096

20

65053

4

68464

16

D3953-9 Manufactured No

100 Each

2.0000

2

2



Gas Spring Washer

Location

Loc Qty

Loc Code

ST096

2

68231

2

D3953-17 Manufactured No

100 Each

9.0000

2

2



Gas Spring Spacer

Location

Loc Qty

Loc Code

ST096

9

67968

9



69513



69977



69975 1x

71885 1x



69973



69603 1x

71870 1x

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Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 69485

Parent Item: D4030-041


Parent Item Name: Long Basket Assembly (350)

Start Date: 5/11/2011


Required Date: 5/13/2011

Start Qty: 1.00


Required Qty: 1.00

D3953-19	Manufactured	No	100	Each	20.0000	1	1	
								
Gas Spring Bracket								


<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	20	
59213	1	
68462	19	

D3953-21	Manufactured	No	100	Each	19.0000	1	1	
								
Gas Spring Bracket								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	19	
68463	19	

D3969-3	Manufactured	No	100	Each	20.0000	1	1	
								
Spring (Basket Lid)								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST272	20	
64285	1	
68925	19	

AN3-14A	Purchased	No	100	Each	21.0000	4	4	
								
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	21	
117513	21	

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Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Work Order ID: 69485

Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011



Start Qty: 1.00

Required Qty: 1.00

AN3-16A	Purchased	No	100	Each	151.0000	2	2	
								



Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	151	
114752	1	
116419	50	
117441	100	

AN5-17A	Purchased	No	100	Each	112.0000	4	4	
								



Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	112	
116590	32	
117313	30	
117619	50	

AN4-12	Purchased	No	100	Each	74.0000	3	3	
								

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	74	
116786	14	
117514	60	

AN310-4	Purchased	No	100	Each	26.0000	3	3	
								

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST324	26	
117442	26	

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 5

Work Order ID: 69485

Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011



Start Qty: 1.00

Required Qty: 1.00

AN310C4 Purchased No 100 Each 59.0000 2 2  



Nut

Location	Loc Qty	Loc Code
ST324	59	
116741	10	
117395	49	

MS21042L3 Purchased No 100 Each 2,328.000 6 6  

Nut

Location	Loc Qty	Loc Code
ST300	2328	
116391	11	
116540	351	
116549	766	
117441	800	
117601	400	

MS21042L5 Purchased No 100 Each 1,283.000 4 4  

Nut

Location	Loc Qty	Loc Code
ST300	1283	
116105	323	
116548	260	
117441	500	
117591	100	
117611	100	

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, May 11, 2011 12:55:40 PM

Page 6

Work Order ID: 69485



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-151 Purchased No

100

Each

483.0000

3

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

483

17566

483

MS24665-300 Purchased No

100

Each

80.0000

2

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

80

116823

80

NAS1149F0432P Purchased No

100

Each

474.0000

6

6



Washer

Location

Loc Qty

Loc Code

ST275

474

117291

474

NAS1149F0563P Purchased No

100

Each

48.0000

4

4



Washer

Location

Loc Qty

Loc Code

ST275

48

114576

48

NAS1149F0332P Purchased No

100

Each

100.0000

8

8



WASHER

Location

Loc Qty

Loc Code

ST275

100

17317

100

Wednesday, May 11, 2011 12:55:40 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 12:55:40 PM

Page 7

Work Order ID: 69485



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

6,274.000

2

2

✓



Washer

C up/2 ①

Location

Loc Qty

Loc Code

ST297

6274

116900

1274

117291

5000

116900

Wednesday, May 11, 2011 12:55:40 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

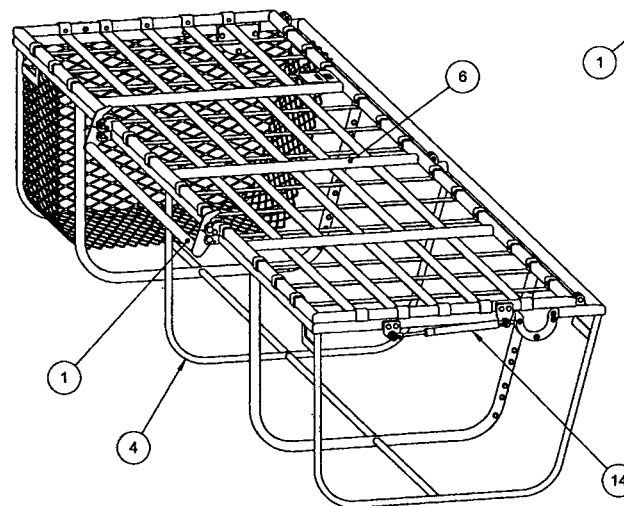
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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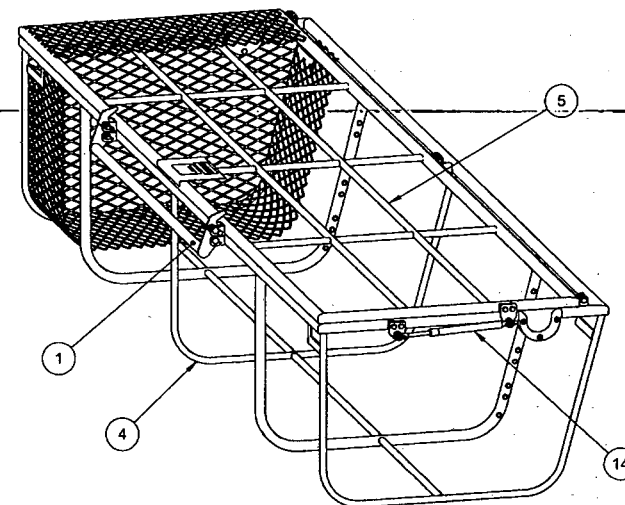
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET, LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *09485*
PL11-0511



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12
ECN 10-596

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (BB-1); QTY FOR ITEM #3 WAS 4 (D6-1) ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>JES</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D4030		REV. C	SHEET 1 OF 3
TITLE LONG BASKET ASSY (350)		SCALE	NTS
<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
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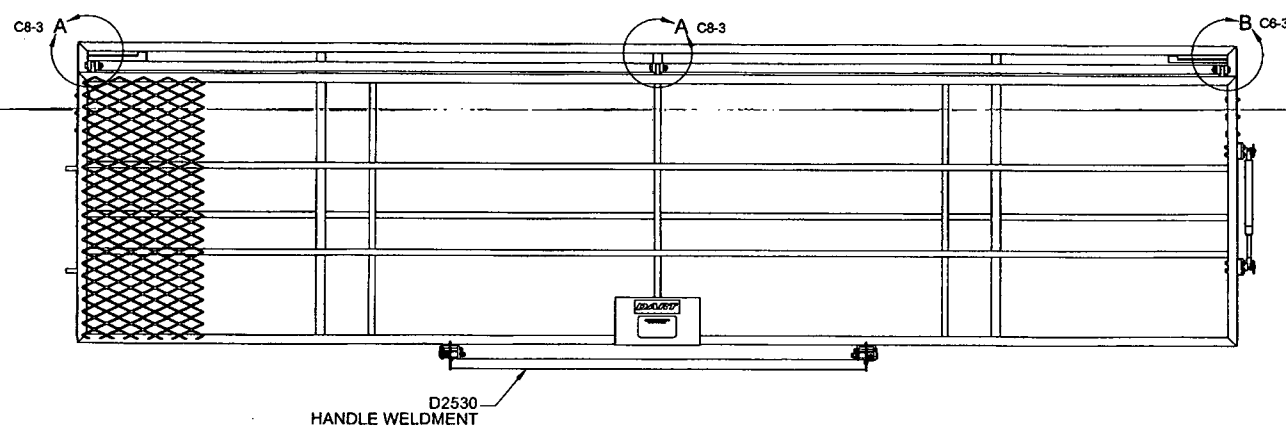
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

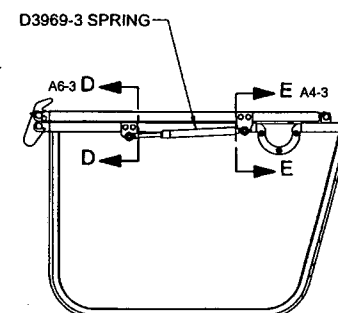
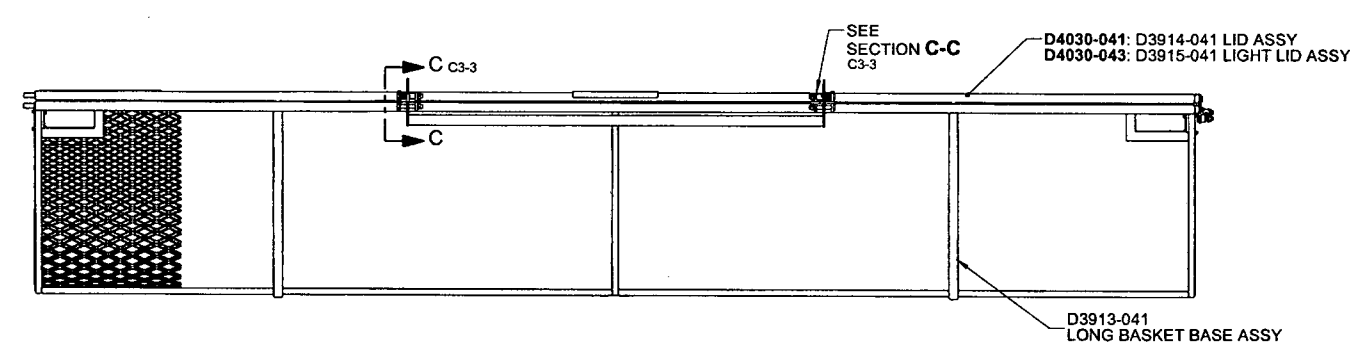
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



w/o 69485



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17.09

DESIGN	AS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	SE	D4030	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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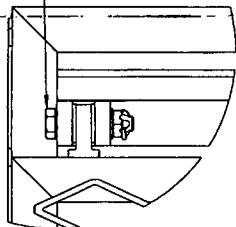
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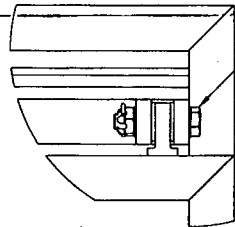
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



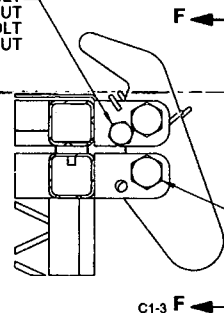
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

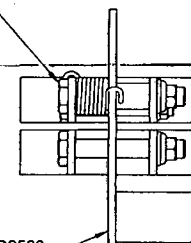


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT

D2530
HANDLE WELDMENT
REF



VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.24

DESIGN	AFS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350) NT	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries